

Work Order ID 81359

March-13-12 1:47:52 PM

81359

Page 1

Item ID: D3535-39 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 13/03/2012 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 27/03/2012 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/13 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev B

100 0.00
100 FLOW WATER JET (18) B12-4-17
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3535 Dwg Rev: B Prog Rev: B 2-
 304 . 046 Debur if necessary

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control B12-4-17

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control (18) ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81359

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Page 2

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 Start Date: 13/03/2012 Start Qty: 16.00 ***16*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	NC BRAKE	0.00							
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130

Brake NC

Brake NC

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326. Identify as D3535-41 Form Joggle on brake using Jig DT8158 as per Dwg D3535

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Quality Control

Memo

0.00

8/26/12

18

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

3:20

3200F

3:50

18X

M-L

12/6/12

WA 117338

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Work Order ID 81359

March-13-12 1:47:52 PM

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Page 3

Item ID: D3535-39

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearshoe

Start Date: 13/03/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 27/03/2012 Req'd Qty: 16.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00				18	0		12-4-26
Quality Control									
170	Identify as per dwg & Stock Location: <i>FPI</i>	0.00							
170									
Packaging	Memo	0.00				18	0		12-4-26
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							12-4-26
Quality Control									

12-04-26

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Picklist Print

March-13-12 1:47:56 PM

Page 1

Work Order ID: 81359

81359

Parent Item: D3535-39

D3535-39

Parent Item Name: Wearshoe

Start Date: 13/03/2012

Required Date: 27/03/2012

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	163.6165	0.951	16.01684	17.		

M304S20GA

B12-4-17

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

163.6165

116623

0.2

117933

27.3442

118400

21.1723

118964

36.5

119346

29.8

120604

48.6

121380

121380

(18)

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DART AEROSPACE LTD		Work Order:	81359
Description: Wearshoe		Part Number:	D3535-39
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
36.815	+/-0.010	36.815	✓		T (Bo)	
32.775	+/-0.010	32.775	✓		T	
29.275	+/-0.010	29.275	✓		T	
25.775	+/-0.010	25.775	✓		T	
23.250	+/-0.010	23.250	✓		T	
19.750	+/-0.010	19.750	✓		T	
17.750	+/-0.010	17.750	✓		T	
14.250	+/-0.010	14.250	✓		T	
9.500	+/-0.010	9.500	✓		T	
4.750	+/-0.010	4.750	✓		T	
2.000	+/-0.010	2.000	✓		T	
5.00	+/-0.030	5.00	✓		T	
9.00	+/-0.030	9.00	✓		T	
28.00	+/-0.030	28.00	✓		T	
Ø0.188	+0.005/-0.001	.192	2		V (Bo)	
1.885	+/-0.010	1.885	2		V	
0.300	+/-0.010	.308	2		V	
0.300	+/-0.010	.305	2		V	
0.038	+/-0.010	.036	2		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-4-17	Date: 12/06/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	B

Dart Aerospace Ltd

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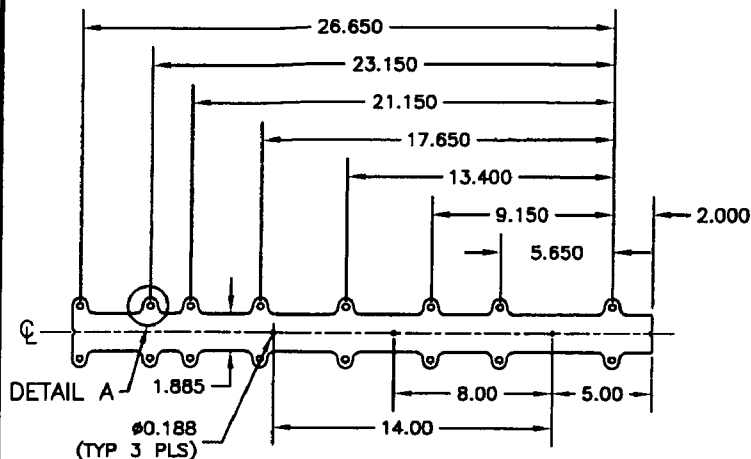
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07.04.24

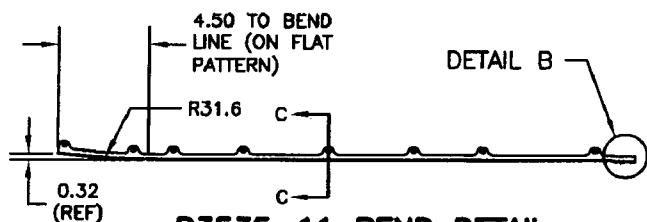
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81359 MLJ

12/03/13

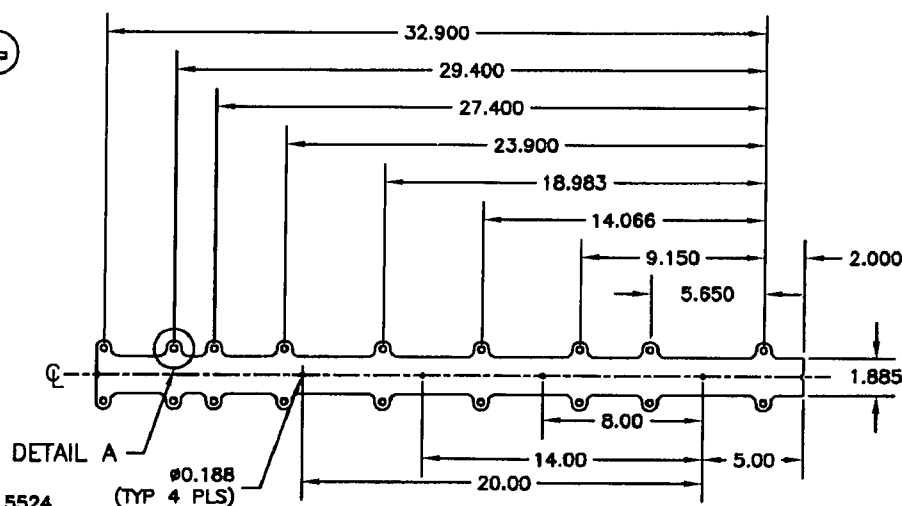
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
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DATE	TITLE	SHEET 1 OF 7
07.04.17	WEARSHOE	SCALE
		1:10
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC



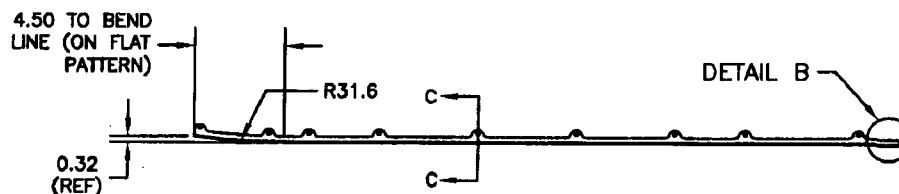
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
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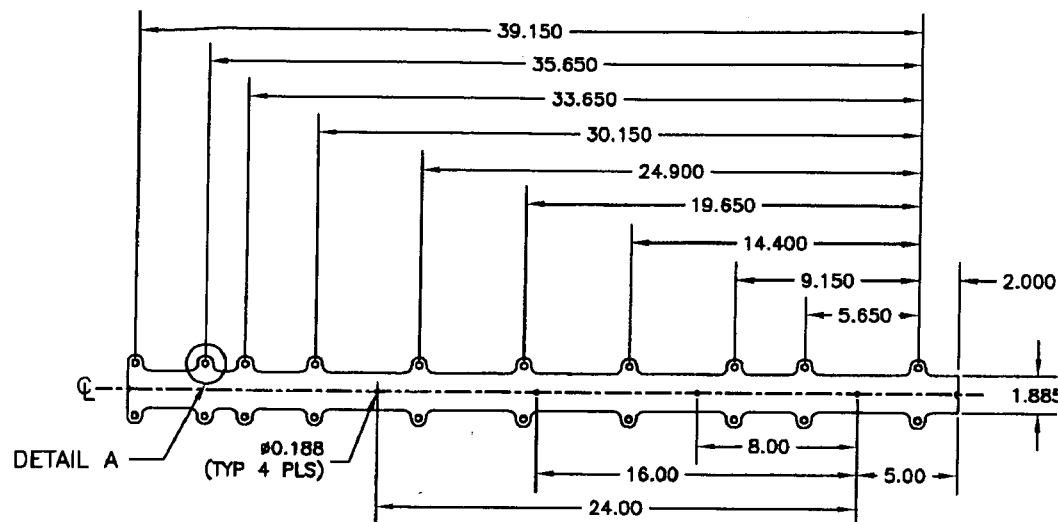
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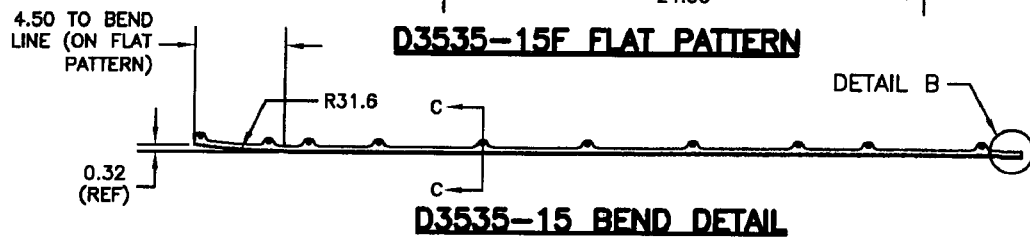
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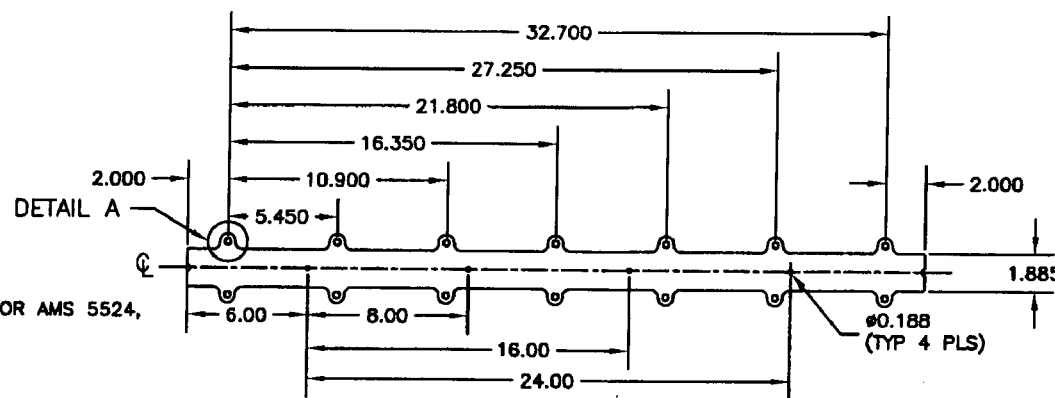
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 2 OF 7
		SCALE 1:10



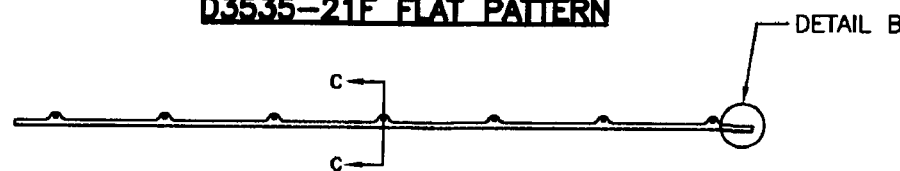
D3535-15F FLAT PATTERN



D3535-15 BEND DETAIL



D3535-21F FLAT PATTERN



D3535-21 BEND DETAIL

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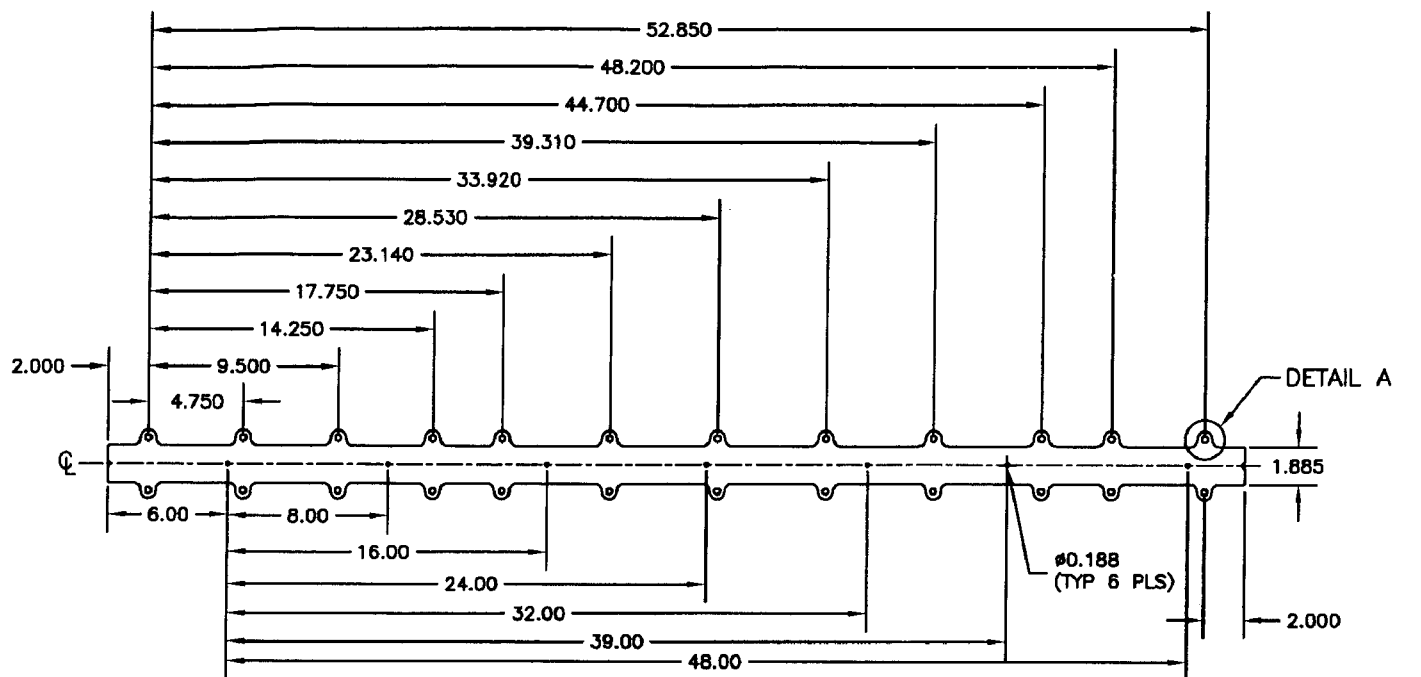
NOTE: Date & initial all entries

DART

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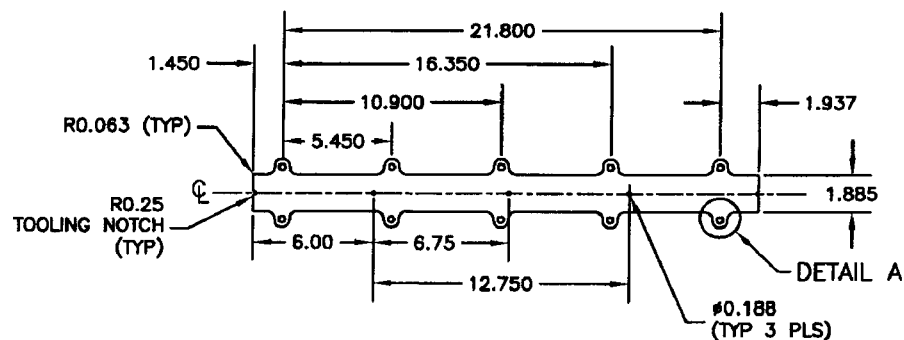
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07.04.24

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CHECKED		APPROVED		PORT HADLOCK, WA	
DATE	07.04.17	DRAWING NO.	D3535	TITLE	WEARSHOE
				SHEET 3 OF 7	SCALE 1:10



D3535-23F FLAT PATTERN

D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN

D3535-25 BEND DETAIL

NOTES

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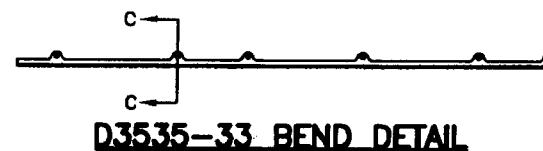
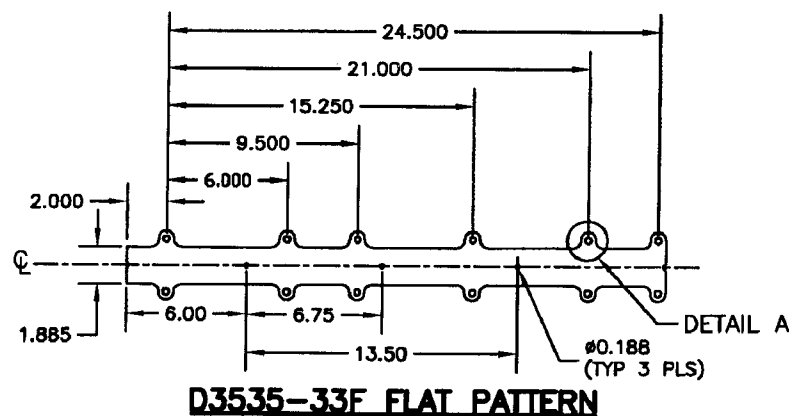
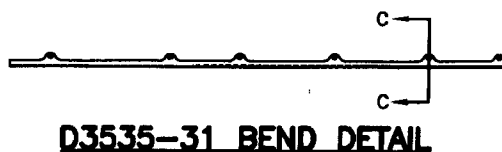
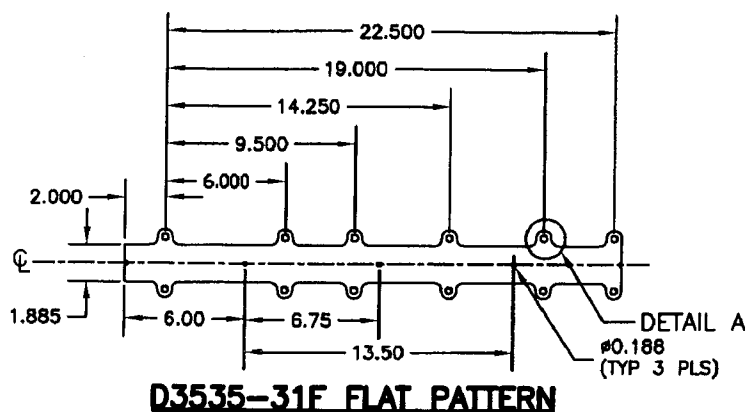
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CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

81359

RELEASED
07.04.24**NOTES**

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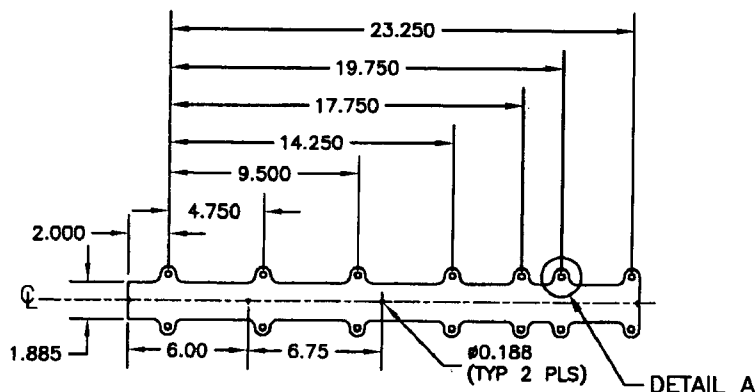
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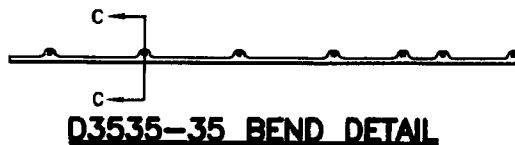
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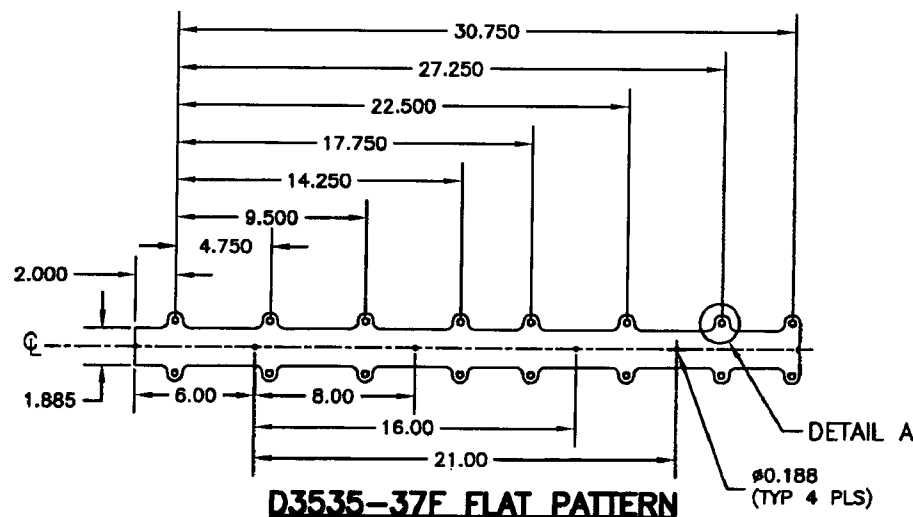
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DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 5 OF 7
		SCALE
		1:10



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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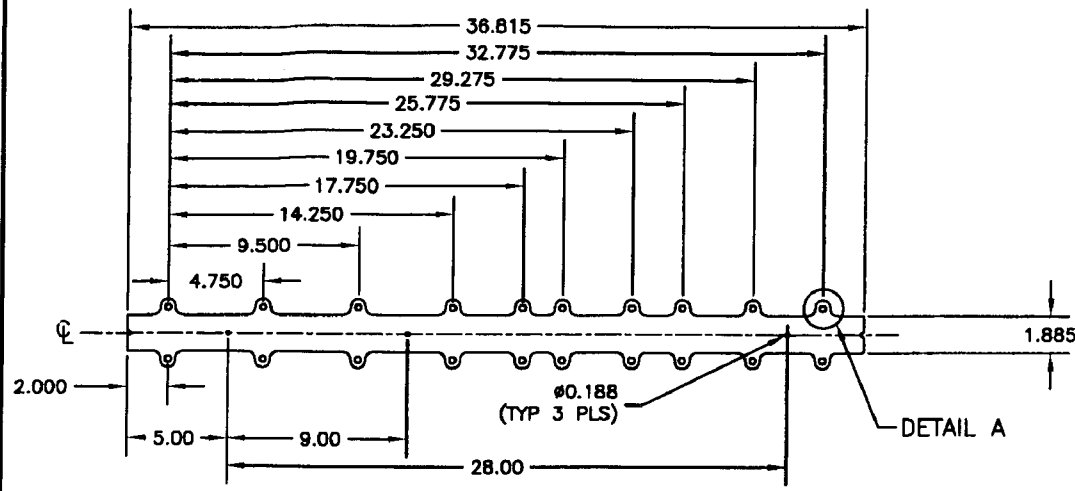
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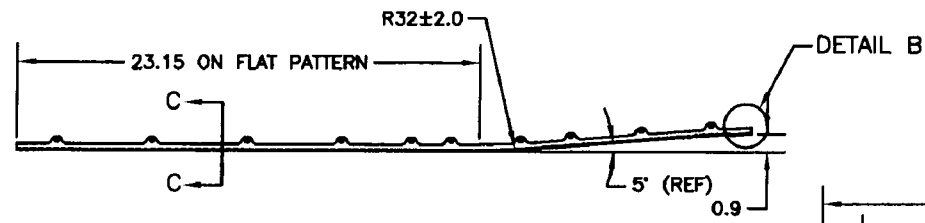


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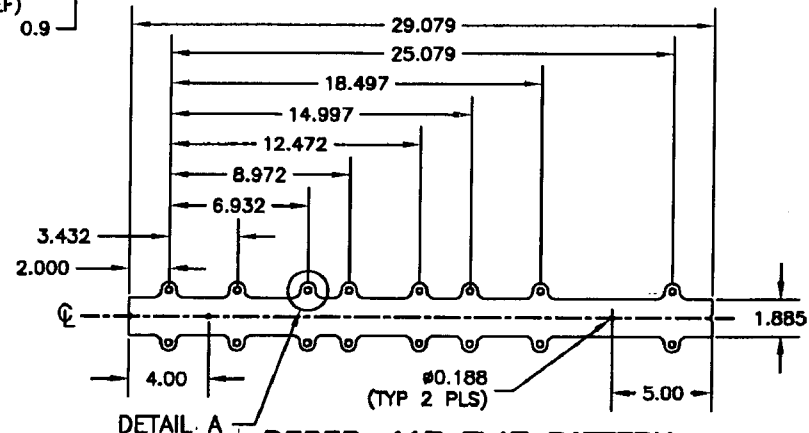
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



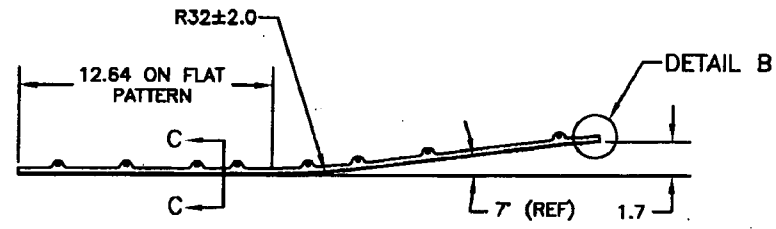
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

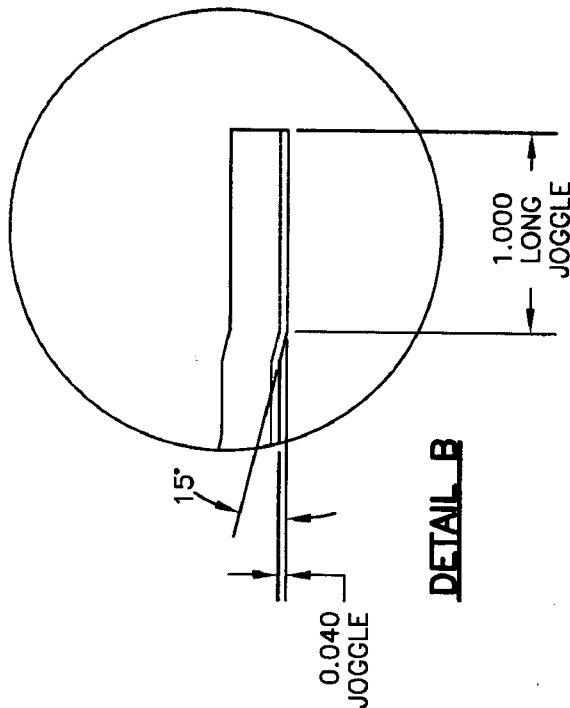


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

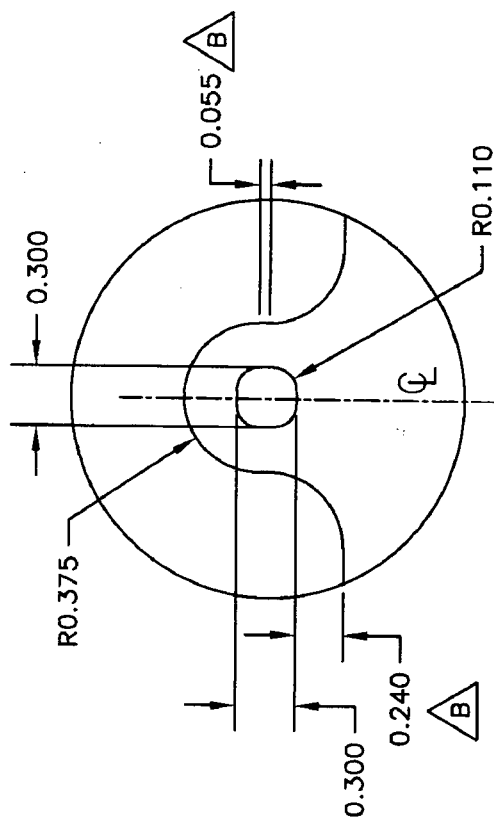
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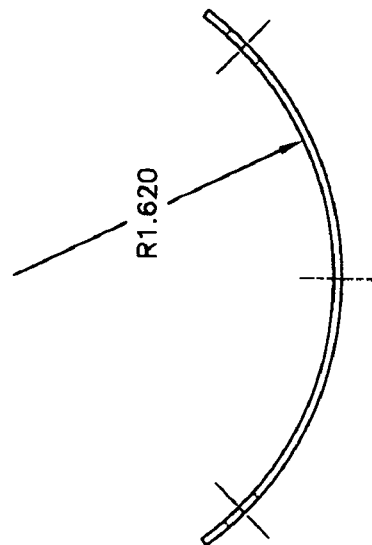
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DETAIL B



DETAIL A



SECTION C-C

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries